

**Work Order ID 62732**

Wednesday, October 06, 2010 2:38:49 PM



Page 1

Item ID: D3947-1

Accept



Setup Start



Revision ID:

Item Name: Panel, Upper LH Post

Stop



Start Date: 10/6/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: *H*

Date: 10-0-04

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3947	A	

100 0.00



HAND FINISHING THERMOFORMING

HandThermo

Memo

0.00

Hand Finishing Thermoforming Cut Blanks to fit frame size

*BB  
10/06/05*

105 0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming Dry Sheet as per QSI022 POLYCARBONATE

Temp: *240 F*Time IN: *4:30 10/06/05*Time OUT: *7:00 10/06/06**BB  
10/10/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



HAND FINISHING THERMOFORMING

Thermoform

Thermoforming Machine

0.00

Memo

0.00

Trim to Finished Dimensions as per dwg D3946-1

Dh *(X3)* 10/10/06.

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Check dimensions to ensure conformity to drawing tolerances.

Dh *(X3)* 10/10/06.

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*8/10/10/12*  
0.00

Memo

*(X3)* \_\_\_\_\_  
-1

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Item Name: Panel, Upper LH Post

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Start Date: 10/6/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location: 148

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF

10-10-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

Page 1

Wednesday, October 06, 2010 2:38:53 PM

Work Order ID: 62732



Parent Item: D3947-1



Parent Item Name: Panel, Upper LH Post

Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: New issue DD verified by:EC  
Add Step 105 Dry Material 10/04/21 DL

IPP RevB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,862.321	3.3055	10.43842			

GE PLASTICS LEXAN SHEET

Location	Loc Qty	Loc Code
therm	1862.321	
107574	6.46	
111973	23.915	
112176	101.2267	
114459	1730.7193	

BB/10/06

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DART AEROSPACE LTD	Work Order:	62732
Description: Panel, Upper RH	Part Number:	D3947-2
Inspection Dwg: D3947	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: SH Date: 10/10/06

#### TRIMMING SECTION

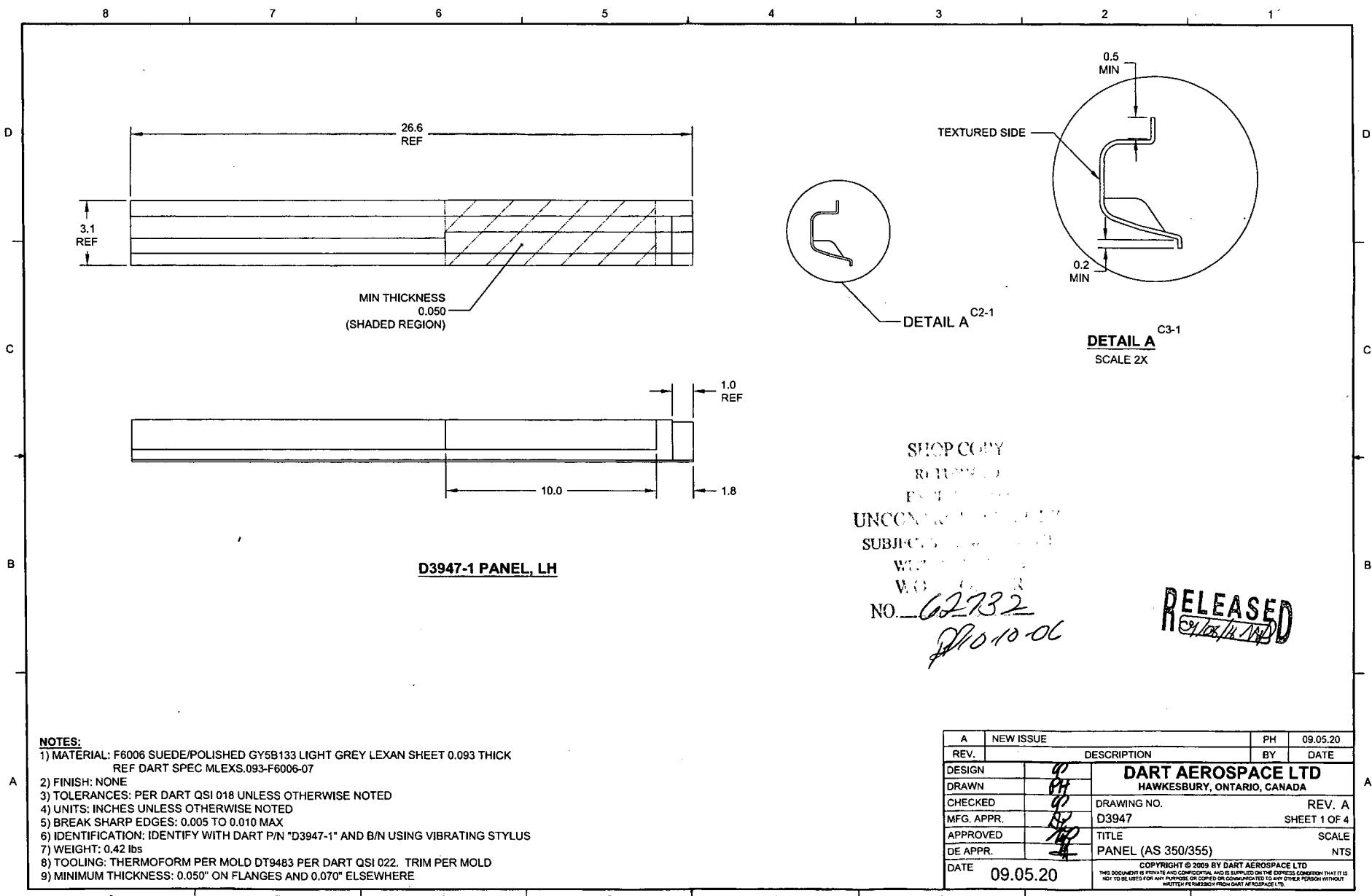
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.0	Min	10.0"	✓			
0.2	Min	0.25"	✓			
0.5	Min	0.505"	—			
1.8	Min	1.875"	✓			
3.1	REF	3.125"	✓			
26.6	REF	26.730"	✓			
0.050	Min	0.054"	—			
0.070	Min	0.076"	✓			

Measured by: SH Date: 10/10/06

Audited by: JB Date: 10/10/06

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>SH</u> <u>JK</u>



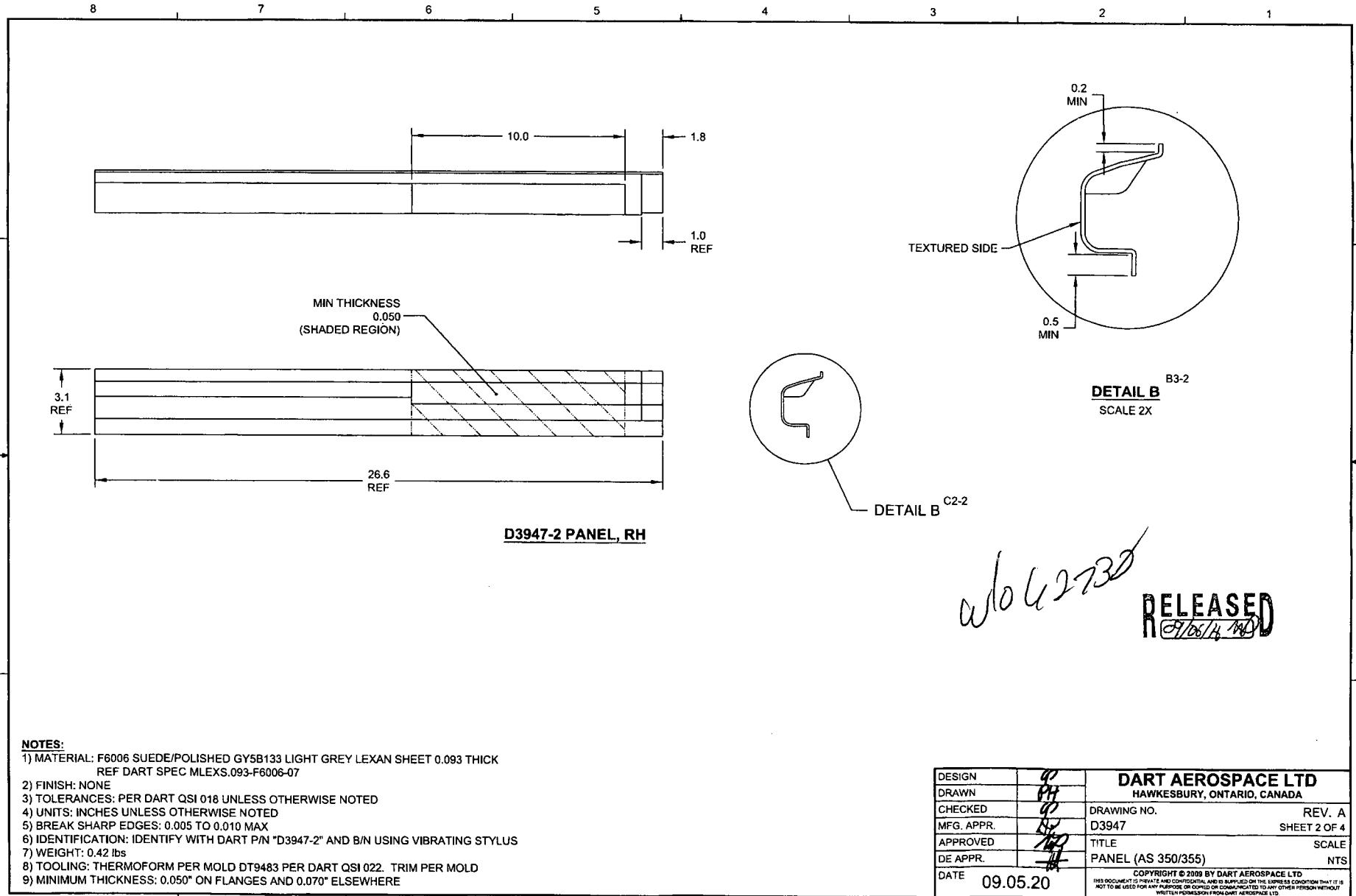
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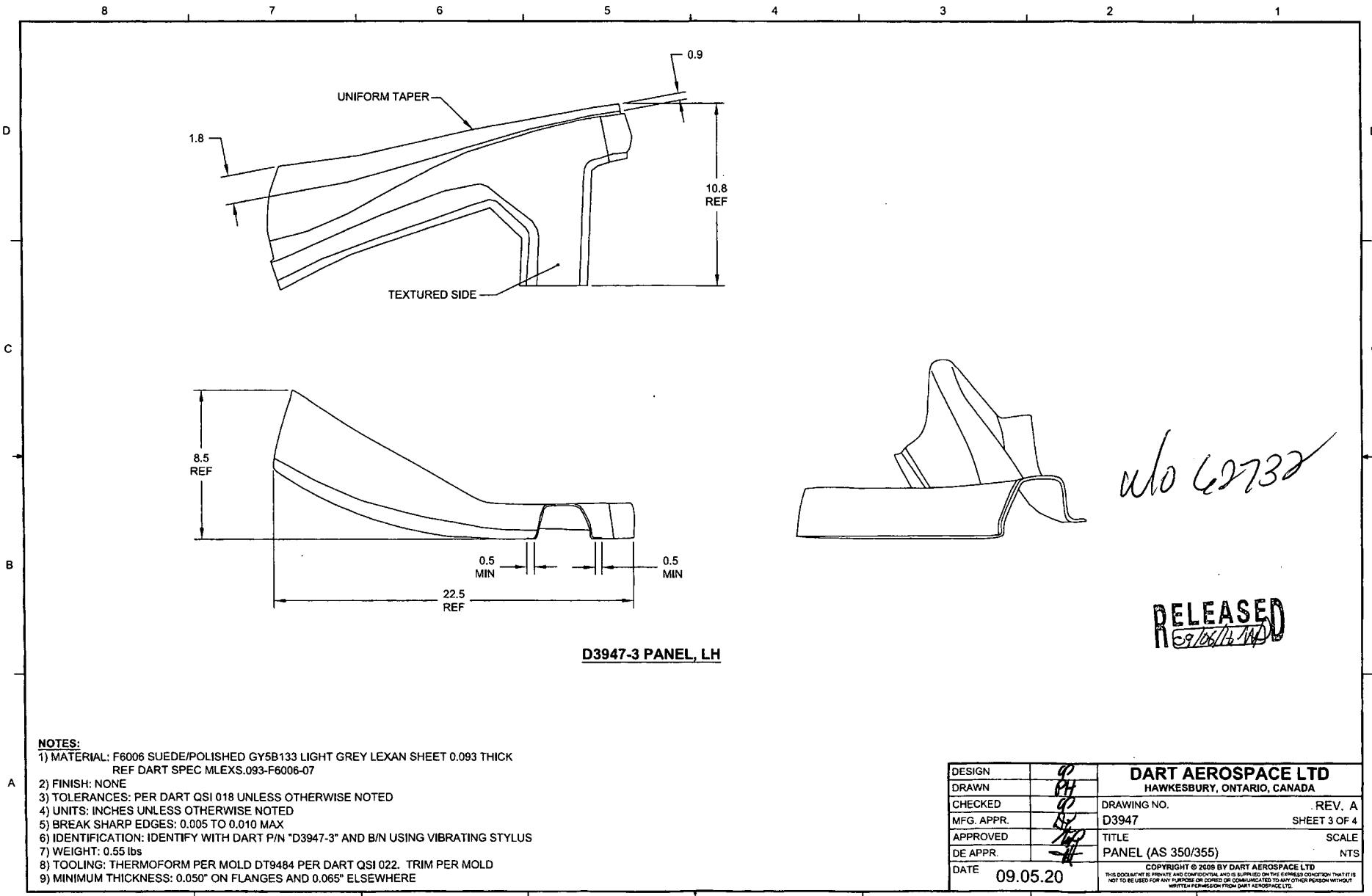
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8 7 6 5 4 3 2 1

D

C

B

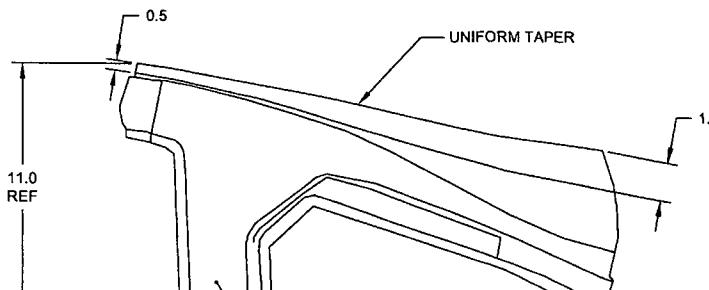
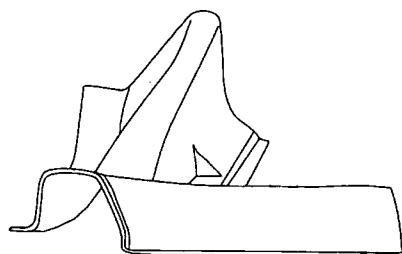
A

D

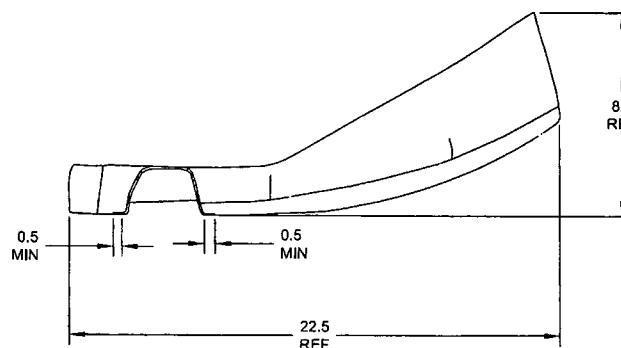
C

B

A



u/o G2732



D3947-4 PANEL, RH

RELEASED  
09/05/20

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-4" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.62 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

DESIGN	90	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	
MFG. APPR.	SP	REV. A	
APPROVED	SP	SHEET 4 OF 4	
DE APPR.	SP	TITLE	
DATE	09.05.20	SCALE	
		PANEL (AS 350/355)	
		NTS	

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8 7 6 5 4 3 2 1

A

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